

SPLIT

Work Order ID 54852 -1



Page 1

December 30, 2009 7:49:21 AM

Item ID: D350-588-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Aft Door Fwd Hinge Modification

Start Date: 12/30/09 Start Qty: 10.00

Required Date: 12/31/09 Req'd Qty: 10.00

Cust Item ID:

Customer:

Reference:

Run Start



Stop



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D350-588-011 CHG002

5/10/10/07

110

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

10-1-4

6
10x SP

120

0.00



QC4- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

2) 5/10/10/07

76



Picklist Print

December 30, 2009 7:48:47 AM

Page 1

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C1032R7  Screw	<i>+2</i>	Purchased	No			120	Each	136.0000	20.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

136

104394

3

113064

100

113096

33

10-1-4 sf

AN526C832R8



Screw

Purchased

No

120

Each

84.0000

80.0000



20

10-1-4

sf 10x

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

84

108335

1

111900

83

75

Picklist Print

December 30, 2009 7:48:48 AM

Page 2

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN526C832R9	88	Purchased	No			120	Each	145.0000	80.0000			



Screw



10-1-4

10081

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

145

107376

51

108377

5

108928

14

110372

8

110915

1

111916

1

112492

65

53

December 30, 2009 7:48:48 AM

Shop Packet Print

Page 2

Picklist Print

December 30, 2009 7:48:48 AM

Page 3

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10 Washer	24	Purchased	No			120	Each	1,444.000	40.0000			

10-1-4 sl 10x

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	1444	
105442	8	
109059	2	
109840	23	
110139	2	
110985	202	
111279	5	
111668	48	
112314	132	
112369	22	
113149	1000	

125
40

Picklist Print

December 30, 2009 7:48:49 AM

Page 4

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD8 Washer		Purchased	No			120	Each	1,047.000	24x 240.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1047

107091

9

108335

11

110382

48

110917

3

111578

60

112314

196

112385

720

Manufactured

No

120

Each

29.0000

10.0000

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

29

37739

29

D2143

Hinge Bracket

December 30, 2009 7:48:49 AM

Shop Packet Print

Page 4

Picklist Print

December 30, 2009 7:48:49 AM

Page 5

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

S 46
D2144
Hinge Bracket

Manufactured No

120

Each

14.0000

10.0000



10-1-4

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

14

41174

14

Manufactured No

120

Each

16.0000

20.0000



10-1-4

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

45813

16

Manufactured No

120

Each

60.0000

20.0000



10-1-4

SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

60

51407

60

20

S 46
D2150
Packer Doubler, Hinge

S 46
D2151
Packer Doubler, Hinge

December 30, 2009 7:48:49 AM

Shop Packet Print

Page 5

Picklist Print

December 30, 2009 7:48:50 AM

Page 6

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2153 Door Prop		Manufactured	No			120	Each	32.0000	10.0000			

Warehouse
Location
Main Warehouse

ST

48373

Loc Qty

32

32

Loc Code

10

Manufactured No

120

Each

29.0000

10.0000

10-1-4

sf

10

Warehouse
Location
Main Warehouse

ST

44890

45814

Loc Qty

29

19

10

Loc Code

1

Picklist Print

December 30, 2009 7:48:51 AM

Page 7

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2237

Manufactured

No

120

Each

64.0000

20.0000



Striker Plate

10-1-4

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

46162

9

Main Warehouse

ST022

55

52327

55

D2461

Manufactured

No

120

f

170.7040

76.3158



Neoprene "D" Seal

18

10-1-4

10sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

170.7039842

34304

14.234

39782

156.469984

cut 1 X 87.00" → measure Solaray

December 30, 2009 7:48:51 AM

Shop Packet Print

Page 7

Picklist Print

December 30, 2009 7:48:52 AM

Page 8

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2463 Seal		Manufactured	No			120	f	569.9926	76.3158			



Seal

10-1-4

sf

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

75.3752

31350

1.8278

34305

18.25

41121

3.75

43841

51.5474

Main Warehouse

ST404

494.6173684

50075

494.617368

cut 1 X 87.00

D2583



Latch Bracket

Manufactured No

120 Each

36.0000

20.0000

10-1-4

sf

10x

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

36

36043

2

48648

2

53889

32

20

December 30, 2009 7:48:52 AM

Shop Packet Print

Page 8

Picklist Print

December 30, 2009 7:48:59 AM

Page 9

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2585  Mounting Channel		Manufactured	No			120	Each	90.0000	20.0000			

10-1-48 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	64	
45888	4	
53798	60	
Main Warehouse		
ST37	26	
51526	26	

D2586

Door Latch

Manufactured No 120 Each 89.0000 20.0000

20

10-1-4

10 SP

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	89	
45554	1	
47183	2	
50213	86	

2



Picklist Print

December 30, 2009 7:48:59 AM

Page 10

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2587  Door Slug, 350 Hinge		Manufactured	No			120	Each	48.0000	10.0000			

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

48

48647

48

Manufactured

No

120

Each

56.0000

10.0000

10

10-1-4

sl

Warehouse

Loc Qty

Loc Code

Location

HONG KONG

ST

1

46840

15

46846

1

50378

40

Manufactured

No

120

Each

18.0000

10.0000

10

10-1-4

sl

10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST41

18

50666

18

10

D2690-17



Cable

December 30, 2009 7:48:59 AM

Shop Packet Print

Page 10

Picklist Print

December 30, 2009 7:49:04 AM

Page 11

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification


Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2857-1 <i>+1</i>  Hinge Bracket		Manufactured	No			120	Each	29.0000	10.0000			

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

29

41166

7

45788

4

50235

6

53464

12

10-1-4

sf

D2857-2 *+1*

Hinge Bracket

Manufactured

No

120

Each

25.0000

10.0000

10-1-4

sf

10

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

25

45797

13

53465

12

10

Picklist Print

December 30, 2009 7:49:04 AM

Page 12

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification




Start Date: 12/30/09

Required Date: 12/31/09

Comments:

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2858-1 <i>x1</i>  Hinge Bracket		Manufactured	No			120	Each	27.0000	10.0000		10-1-4	sf
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>43364</div> <div>45798</div> <div>Loc Qty</div> <div>27</div> <div>3</div> <div>24</div> <div>Loc Code</div> <div></div> <div></div> <div></div>												
D2858-2 <i>x1</i>  Hinge Bracket		Manufactured	No			120	Each	19.0000	10.0000		10-1-4	sf
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>41439</div> <div>45799</div> <div>Loc Qty</div> <div>19</div> <div>4</div> <div>15</div> <div>Loc Code</div> <div></div> <div></div> <div></div>												
FG-778150-550-ROL <i>x1</i>  7781 9oz Glass 50"x125yd		Purchased	No			120	sf	855.0000	10.0000		10-1-4	sf 10
<div>Warehouse</div> <div>Location</div> <div>Main Warehouse</div> <div>ST</div> <div>111166</div> <div>Loc Qty</div> <div>855</div> <div>855</div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div>												
1- cut 1 square ft of glass cloth												

December 30, 2009 7:49:04 AM

Shop Packet Print

Page 12

Picklist Print

December 30, 2009 7:49:10 AM

Page 14

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L08 <i>x18</i>		Purchased	No			120	Each	317.0000	180.0000			



Nut

-4

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

317

110002

24

111889

30

112243

43

112492

24

112612

1

112794

7

113226

188

**4 => 174*

MS21042L3 *x4*

Purchased

No

120

Each

3,314.000

40.0000



Nut

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

3314

110844

35

111274

27

111668

64

112314

1688

112385

500

113523

300

113537

700

40

December 30, 2009 7:49:10 AM

Shop Packet Print

Page 14

Picklist Print

December 30, 2009 7:49:15 AM

Page 15

Work Order ID: 54852

Parent Item: D350-588-011

Parent Item Name: Aft Door Fwd Hinge Modification

Comments:

Start Date: 12/30/09

Required Date: 12/31/09

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-08-11	72	Purchased	No			120	Each	76.0000	20.0000			
											10-1-4	SVL

Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

76

111977

76

120

Each

163.0000

20.0000

20

10-1-4

SVL

MS27039-1-15

72

Purchased

No

Screw

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

163

106903

3

108169

4

109321

4

111916

52

112794

100

20

52.3 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg

* D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

588 -041	588 -011	Part Number	Description
X		D350-588-041	AFT DOOR ASSEMBLY
	X	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
1	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
2	2	D2150	HINGE PACKER
2	2	D2151	HINGE DOUBLER
1	1	D2153-3315-10	GAS SPRING ASSY.
1	1	D2154	STUD BRACKET
2	2	D2237	STRIKER PLATE
1		D2445	DOOR
1	1	D2461-0870	NEOPRENE D SEAL
1	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
1	1	D2589	KEYS, KEY CHAIN
2		D2621	LATCH PLATE
1	1	D2690-17	CABLE, DOOR STOP
1	1	D2857-1	LOWER HINGE BRACKET
1	1	D2857-2	UPPER HINGE BRACKET
1	1	D2858-1	LOWER HINGE BRACKET
1	1	D2858-2	UPPER HINGE BRACKET
8	8	AN526C832R8	SCREW (or AN526-832R8)
8	8	AN526C832R9	SCREW (or AN526-832R9)
2	2	AN526C1032R7	SCREW (or AN526-1032R7)
24	24	AN960JD8	WASHER
4	4	AN960JD10	WASHER
12	12	MS20426AD3-4	RIVET
18	18	MS20470AD4-5	RIVET
18	18	MS21042L08	NUT (or MS21042-08)
4	4	MS21042L3	NUT (or MS21042-3)
2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
1	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)

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52-00-00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries